

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019751**Date Inspected:** 16-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Chao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 14, OBG 13 EAST (NWIT # 7802)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3007B-042, 036, 030, 024, 018

SEG3007C-006, 012, 018, 024, 030, 036

SEG3007E-035, 030, 025, 020, 015, 010, 005

SEG3007D-035, 030, 025, 020, 015, 005

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 14

SEGMENT 13AW

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Repair welding by SMAW process of weld joint SEG3013P-262 (B-WR18673) joining Floor Beam (FB) 3177A to stiffener of bottom plate at Panel Point (PP) 118 of segment 13AW. Welder is identified as 066163. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F) FCM-REPAIR.

Repair welding by SMAW process of weld joint SEG3013B-262 (B-WR18686) joining Floor Beam (FB) 3201A to stiffener of bottom plate at Panel Point (PP) 120 of segment 13AW. Welder is identified as 045221. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F) FCM-REPAIR.

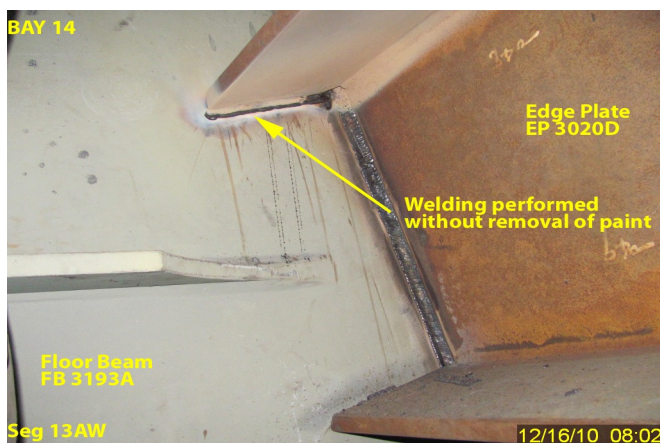
During random in process inspection this QA inspector observed that ZPMC personnel were performing welding on the weld joints joining stiffeners of Edge Plate (EP) 3020D to Floor Beam (FB) 3193A at Panel Point (PP) 119+1500 without removal of paint. This issue has been discussed with AB/F QA Mr. Wei Tian Bo. AB/F QA Mr. Wei Tian Bo informed this QA that ZPMC will remove the paint and then proceed for further fabrication. Attached photograph provide additional details.

### SEGMENT 13BW

Repair welding by SMAW process of weld joint SEG3014J-087 (B-WR18546) joining Floor Beam (FB) 3207A to stiffener of bottom plate at Panel Point (PP) 120.5 of segment 13BW. Welder is identified as 045196. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F) FCM-REPAIR.

Repair welding by SMAW process of weld joint SEG3014G-079 joining Floor Beam (FB) 3211A to stiffener of bottom plate at Panel Point (PP) 121 of segment 13BW. Welder is identified as 045196. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F) FCM-REPAIR.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

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Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Umesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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